

Date:
User:Friday, 7/20/2007 10:22:19 AM
Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT WELDMENT ASS'Y
Job Number	: 33707		
Estimate Number	: 10554		
P.O. Number	: <i>N/A</i>	Part Number	: D34431
This Issue	: 7/20/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D3443 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 29366	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 7/27/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	8 Um: Each
Comment	: A 05.11.14 New issue EC		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M174B2500X1250 17-4 SS BAR



Comment: Qty.: 0.2100 f(s)/Unit Total : 1.6800 f(s)
 Material: 17-4 SS Bar 2.500" X 1.250"
 (M17-4-B2.500x01.250)
 Batch: *M101422*

ml 07/07/26

8

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blank 2.400 " long

ml 07/07/26

8

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA587 Rev: *4A* & Dwg D3443 Rev: *B*

ml 07/07/27

8

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 07/07/27

8

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

IL 07/07/27

8

6.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Tumble & deburr per dwg D3443

ml 07/07/27

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 31/07/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 7/20/2007 10:22:20 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 33707

Part Number: D34431

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

36 07-07-27 (5)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Large Feb.*

07-07-27 (5)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07-07-27 (5)

Job Completion



07-07-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3065-5DART AEROSPACE LTD		Work Order:	33707
Description: Lug		Part Number:	D3443-1
Inspection Dwg: D3443	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

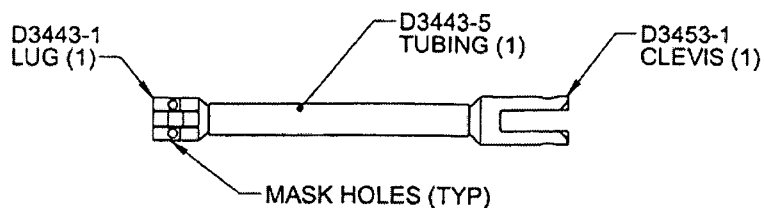
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+/-0.010	1.003	✓			
0.342	+0.000/-0.005	0.341	✓			
0.329	+/-0.010	0.328	✓			
Ø0.500	+0.000/-0.005	Ø0.499	✓			
2.21	+/-0.030	2.216	✓			
Ø0.656	+0.000/-0.001	Ø0.6555	✓			
0.625	+/-0.010	0.630	✓			
0.95	+/-0.030	0.949	✓			
2.230	+/-0.010	2.225	✓			
0.229	+/-0.010	0.230	✓			
0.370	+/-0.010	0.270	✓			
0.525	+/-0.010	0.527	✓			
0.524	+/-0.010	0.527	✓			
0.390	+/-0.010	0.390	✓			
1.048	+/-0.010	1.043	✓			
0.05 x 45°	+/-0.5°	0.050 x 45°	✓			
R0.032	+/-0.010	R0.032	✓			
0.470	+/-0.010	0.467	✓			
0.165	+/-0.010	0.165	✓			
1/4-28UNF	N/A	1/4-28UNF	✓			

Measured by: <i>JLM</i>	Audited by: <i>JLM</i>	Prototype Approval:	N/A
Date: 07/07/26	Date: 07/07/26	Date:	N/A

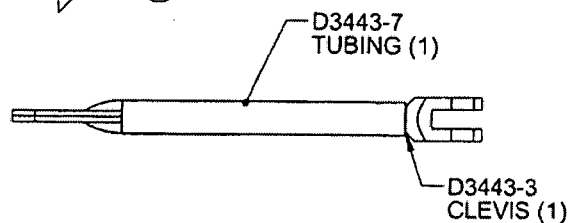
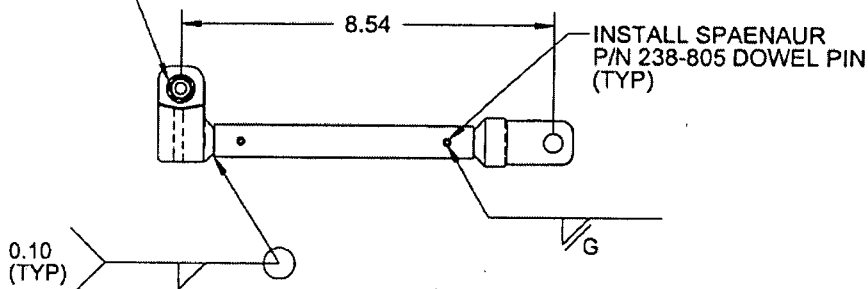
Rev	Date	Change	Revised by	Approved
A	06.07.11	New Issue	KJ/JLM <i>AK</i>	<i>BE</i>

DART

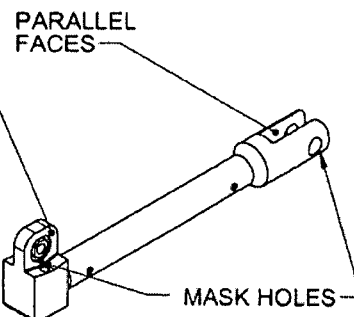
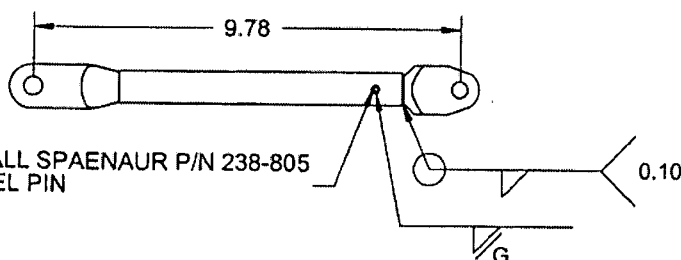
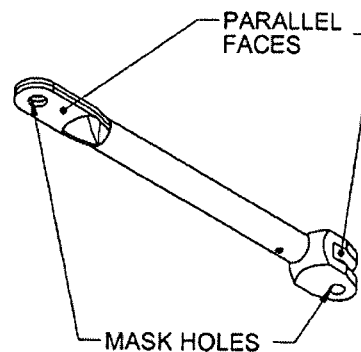
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3443	REV. B SHEET 1 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY SCALE 1:4		
A	05.09.02	NEW ISSUE	
B	05.12.05	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & Ø0.125 WAS #30	

RELEASED05.12.09 *[Signature]*

PRESS FIT McMASTER-CARR P/N 63215K32
BALL JOINT BEARING AFTER POWDER COAT



INSTALL SPAENAU P/N 238-805
DOWEL PIN

**D3443-041****D3443-043**

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WITHOUT NOTICE

WORK ORDER

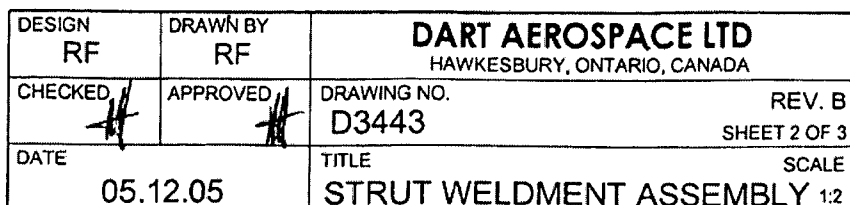
NO. **33707**

NOTES:

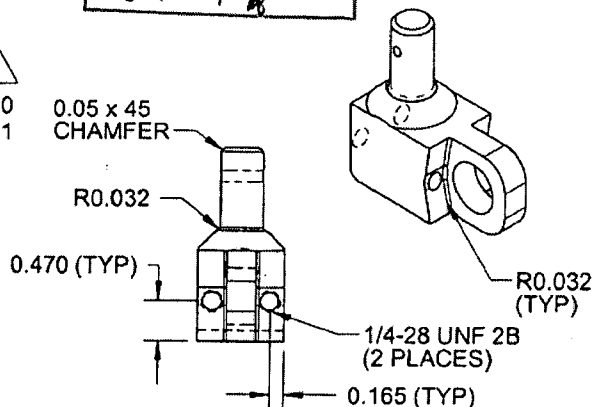
- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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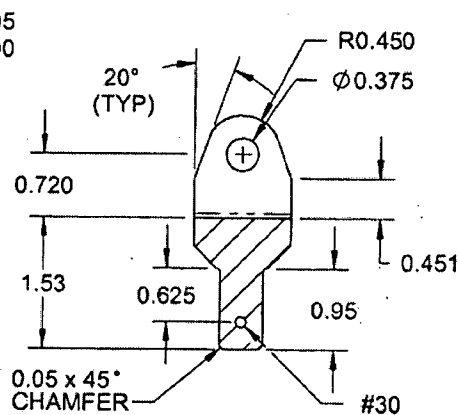
05.12.09



D3443-1 LUG

D3443-1 NOTES:

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)



SECTION A-A

D3443-3 CLEVIS

D3443-3 NOTES:

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

GENERAL NOTES:

- 2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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ED WORK ORDER
NO. 33707

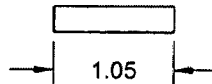
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3443	REV. B SHEET 3 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY 1:2		

$\varnothing 0.210^{+0.005}_{-0.010}$



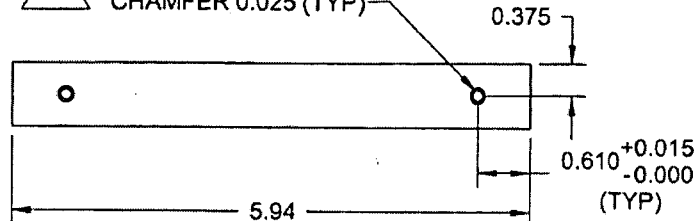
D3443-9 PIN

D3443-9 NOTES:

- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAIL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

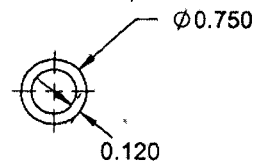


DRILL $\varnothing 0.125$ THRU
CHAMFER 0.025 (TYP)



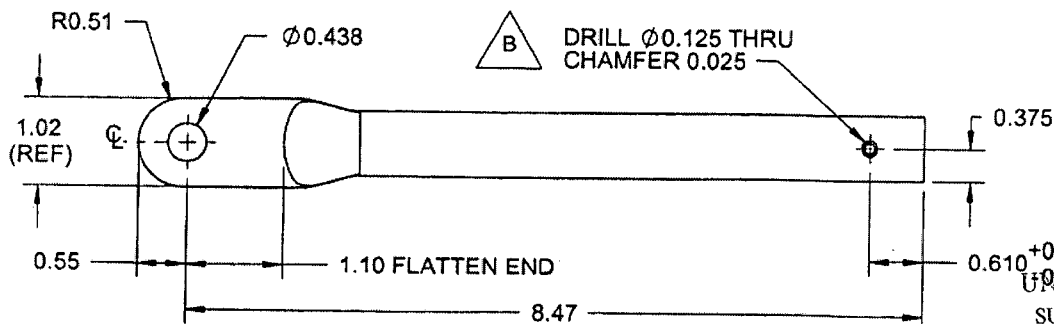
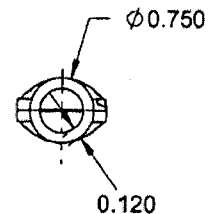
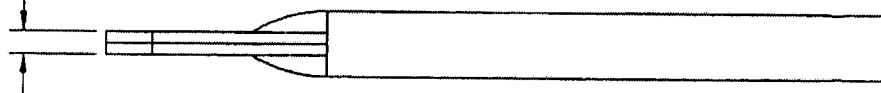
RELEASED

05.12.09



D3443-5 TUBING

$0.260^{+0.000}_{-0.030}$



D3443-7 TUBING

D3443-5/-7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.7500W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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